Work Order II Friday, October 26, 2			*923	27*				Page 1
Revision ID:	2-709-011 be Panel Modification		Accept	*N9000	<u>140100</u>)* ′ s	Setup Start Stop	1/1/2
Start Date: 10/26 Required Date: 10/26	5/2012 Start Qty: 1.00	*1* *1*		Cust Item ID):			14.32
Approvals: Pro	cess Plan:	Date: 12/10'2 Date:	Pooling: SPC (Y/N):	W	te:	R	Run Start Stop	*NR1* *NR2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool # Plan Code	Accept Qty		Reject Insp. Number Stamp
Draw Nbr	Revision Nbr			<u>. </u>				
IIN-D412-709	Rev C	0						
*1 \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\	DOCUMENT CONTROL Memo Photocopy bl	Signature of the state of the s	0.00 A 16 0.00 ° s	Muly			MC	5 12-10-2
Ŷ		R. T.						
110	Pick Kit		0.00					
110 Packaging Packaging	Memo		0.00	e en				12/10/26
120	QC4- 100% Inspect kits fo	r completeness	0.00 DAS	12/10/30				,
120 QC Quality Control	Memo		0.00	• •/				

										DQA:	Date:		
NCR: Ye	s / No			479	WORK ORDER NON-C	CON	IFORI	MANCE / UPI					
			2.							QA Closed:	Date:		
Work Order	:				DISPOSITION	ı	AGAINST DEPARTMENT/PROCESS						
Part No					Rework Scrap Use-as-is			Skid-tube Machining	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other	
NCR No		2			Work Order Update			Large Fab	Composite		Supplier		
Root				Descri	ption of work order update		nitial	Act	ion	Sign &		.	
Cause	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector	
Doc/Data								<i>y</i>					
Equip/Tooling										-			
Operator	_			10									
Material										1			
Setup	4												
Other	4						3.6						
Process	4	111			•		•						
Supplier	4						-	- # -					
Training	-												
Unapproved		1	2/	1		<u> </u>	T CATE	CORV				<u> </u>	
Landing	Coor				General	AUL	CAIL	GORT					
	Bending			Г	Bend		Grain			Ovalized		Pressure/Forced	
-	Centre N	ot Conce	ntric to		BOM/Route		Hardwa	are ·		Over/Under	tolerance	Temperature/Cure	
	Cracks	51 6011661		-,,	Broken/Damaged			ion Incomplete		Part Incorre		Weld	

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Instructions Incomplete/Unclear

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Part Moved

Wrong Stock Pulled

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

Cuffs

Heat Treat

Burrs

Contamination

Countersink

Cut Too Short Drill Holes

Drawing

Finish

Folio

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Work Ord Friday, October					*923					Page		
Item ID: Revision ID:	D412-709-0	11		11	Accept	*N900	040	100)* s	Setup Sta	rt *N	S1*
Item Name:	Escape Panel	Modification								Sto	p *N	S2*
Start Date: Required Date	10/26/2012 : 10/26/2012	Start Qty: 1.00 Req'd Qty: 1.00		*1* *1*		Cust Item I Customer:	ID:					
Reference:				-								
Approvals:	Process Pla	ın:	Date:		Tooling:	D:	ate:		F	Run Sta	1/7	R1*
	QC:		_ Date:_		SPC (Y/N):		ate:	-22 // 1/2		Sto	*N	R2*
Sequence ID/ Work Center I	D	Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Packaging		Packaging Memo			0.00						6/1	208/0
Packaging			pack for shi	pping as per F	PPP D412-709-011							

0.00

0.00

Location:

Memo

QC21- Final Inspection - Work Order Release

140

140 QC

Quality Control

MCS 12-10-30 MF

Page 2

NCR:	Yes / No	WORK ORDER
TVCTV.	103 /s 110	WORK ONDE

WORK ORDER NON-CONFORMANCE / UPDATE

DQA:

Date:

NCK. 1	es ⊱ Mo				WORK ORDER NON-	CONF		IANCL / UPL	DAIL	QA Closed:	Date	:
Work Orde	er.				DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part N					Rework Scrap	7	Skid-tube Crosstube Water Jer Machining Small Fab Prod. Eng. Coor					Engineering Quality
NCR N	lo.				Use-as-is Work Order Update] Th		oforming arge Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other
Root				Descri	iption of work order update	Initia	al	Act	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief	Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data					51					,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,		
quip/Tooling												
Operator							1					
Material								4.0				
Setup										1.0		
Other				•			1					
Process	_											
Supplier		1	4				- 1					
Training						1			(2)		•	
Unapproved		1	<u></u>							1		7. TO 10
						FAULT C	ATEG	ORY				
Landir I	ng Gear			-	General					٦	г	-]_ ,
	Bending				Bend	Gra			_	Ovalized	. .	Pressure/Forced
		lot Conce	ntric to	O/S	BOM/Route	_	rdwar		<u> </u>	Over/Under	_	Temperature/Cure
	Cracks				Broken/Damaged			on Incomplete	_	Part Incorre	<u>-</u>	Weld
		/Crimped			Burrs			ons incomplete/l	Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	-		nance		Part Moved	44	
	Heat Tre				Countersink	-	slabel			Positioned V		-
		on Strip in	Tube	_	Cut Too Short	\vdash	sread		L	Power Loss/	'Surge	Other
	Ripples i				Drill Holes	\vdash	fset					
1	·	Waves in I		n L	Drawing			alibration				
		Sequence			Finish	Ou	it of Se	equence				
•	Wave/T	wist in Tul	be		Folio	Ou	ıtside	Dimensions				

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Work Order ID:

92327

Parent Item:

D412-709-011

Parent Item Name:

Escape Panel Modification

Comments:

IPP Rev:B Removed Manufacturing

05-11-06 JLM

Start Date: 10/26/2012

Required Date: 10/26/2012

Start Qty: 1.00

Required Qty: 1.00

IPP rev C removed sub-components 07 11 12 IPP Rev:D 10.05.20 added D3561-1

	DD verf:EC		07.1	1.12 EC		D 10.05.20 a						
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit Tot Qty		Date Issued	Status
AN6-20A >		Purchased	No			110	Each	23.0000	0	354	4	
S		1		Location		Loc Qty	Le	oc Code		•		
				ST339		20						
				122	416	20				_		
				ST341		3				_		
	,			118	706	3			3	_	-	A
AN960JD10L Washer	/NAS1149D0332J	Purchased	No			110	Each	0.0000		2 M12	2973	S (2)
AN960JD616 Washer	NAS1149D0663J	Purchased	No			110	Each	0.0000	6	5 M123		J. (2
AN960JD616L A	JASIIAd Dopler	Purchased	No			110	Each	0.0000	(<u>-</u>)	5 M1204	18 90	\ \(\gamma\)
D3118-3 Sign Assembly		Manufactured	No			110	Each	0.0000		1 923	365	1/8
Frame		Manufactured	No			110	Each	4.0000		1 SJ		8
				Location		Loc Qty	Lo	oc Code	4.1	1 *		
				ST218		4						
D3239-1.		Manufactured	No	8674	42	110	Each	13.0000	(2)	2 50		85
				Location		Loc Oty	<u>L</u> c	oc Code				
D412-709-013 CH	Vindow	Manufactured	No	ST035	75 -	13 13 110	Each	0.0000		1 92	1328	s {

												DQA:	Da	te:		
NCR:	Yes	/ No				WORK ORDER NON-C	COI	NFOR	MANCE / UF	PDATE	:	QA Closed:	Da	ite:		
		* *:		<u> </u>	*	DISPOSITION				AGAINST DEPARTMENT/PROCESS						
Work Ord	er:						,					1				
Part I	No.		··· <u>-</u> · · ·			Rework Scrap Use-as-is	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing			Prod. Eng. Coo				Engineering Quality Other		
NCR I	No.					Work Order Update]		Large Fab	Composite			Supplier			
Root		', ',,,,,			Descri	ption of work order update		Initial	A	ction		Sign &				
Cause		Date	Step	Qty	(or Non-conformance	Ct	nief Eng	Des	cription		Date	Verificatio	'n	QC Inspector	
Doc/Data															des	
Equip/Tooling																
Operator									4.	, LJ.						
Material																
Setup												.*				
Other				,					4,-						•	
Process																
Supplier																
Training						*						. !				
Unapproved					<u> </u>		<u> </u>									
						F.	AUI	LT CATE	GORY							
Landi	ng (Sear			_	General		,			_	7			1	
		Bending				Bend		Grain			L	Ovalized			Pressure/Forced	
		Centre N	ot Concer	ntric to	o/s	BOM/Route		Hardwa				Over/Under	_		Temperature/Cure	
		Cracks				Broken/Damaged		-i `	ion Incomplete			Part Incorre		Ŀ	Weld	
	Crushed/Crimped Burrs							Instructions Incomplete/Unclear				Part Lost/Missing			Wrong Stock Pulled	

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Part Moved

Positioned Wrong

Power Loss/Surge

Other

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Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Friday, October 26, 2012 3:22:38 PM

Work Order ID:	92327											
Parent Item:	D412-709-011								Start I	Date: 10/26/2012	Required Date: 1	0/26/2012
Parent Item Name:	Escape Panel Modi	fication							Start	Qty: 1.00	Required Qty: 1	
MS2104213		Purchased	No				110	Each	3,019.0000	2 2		
				Location	1		Loc Oty		Loc Code			
,				316	<u></u>		627		<u> Loc Couc</u>			
				310	122452	***	627					
				ST300	122132		338					
,				31500	117885		32					
					119017		168					
					119075		138					
				ST314			1628					
					123265		1628			2		
				ST317	-		426			-		
					122141		426				\wedge	
MS21042L6 Nut		Purchased	No				110	Each	1,045.0000	3 3	_\lambda_	SK
				<u>Location</u>	1		Loc Qty		Loc Code			
				314			266					
					122441		266			3		
				ST300			279					
•					117677		25					
					118384		3					
					118927		48					
					119075 120308		4 199	14				
				CT214	120308					. مغیر		
				ST314	123248		500					
					123248		350 150					
MS35207-262		D	No		123333	ar .	110	Each	262.0000		Λ	1
Screw		Purchased	NO		•		110	Eacii	202.0000	2	St idie	had
				Location	<u>1</u>		Loc Qty		Loc Code			
				ST295			262					
				4	115016		162			_2		
					121014		100					

			Ü
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE	. 04 61-

NCR: Y	es	/ No				WORK ORDER NON-C	CONFC	DRN	MANCE / UP		QA Closed:	Dot			
Work Orde	r.					DISPOSITION		AGAINST DEPARTMENT/PROCESS							
WOIR OIGE	' -					Rework	1		Skid-tube	Engineering					
Part N	io					· –	Rework Skid-tube Crosstul Scrap Machining Small Fo								
	-					Use-as-is	l I Th		oforming	Finishing	Rec/Store/Packaging Other				
NCR N	0.					Work Order Update			Large Fab	Composite	•	Supplier			
						· L	<u> </u>					<u>.</u>			
Root	i				Descri	ption of work order update	Initia	al	Act	tion	Sign &				
Cause		Date	Step	Qty	(or Non-conformance	Chief I	Eng	Desc	ription	Date	Verification	QC Inspector		
oc/Data															
quip/Tooling									ω.						
perator															
/laterial	┙			1											
etup															
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rocess								İ							
upplier								j	.A.						
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						F	AULT C	ATEC	GORY		*				
Landir	ng G	iear				General					,	r			
	\Box	Bending				Bend	Gra	ain			Ovalized		Pressure/Forced		
		Centre No	t Concer	ntric to (o/s	BOM/Route	Har	dwa	re		Over/Under		Temperature/Cure		
		Cracks				Broken/Damaged	Inst	pecti	on Incomplete		Part Incorre	ct	Weld		
6		Crushed/0	Crimped.			Burrs	Inst	tructi	ions Incomplete/	Unclear	Part Lost/Mi	issing	Wrong Stock Pulled		
		Cuffs				Contamination	Ma	inte	nance		Part Moved				
	Heat Treat Countersink					Countersink	Mis	slabe	led		Positioned V	Vrong _			
Inspection Strip in Tube Cut Too Short					Mis	sread	1		Power Loss/	'Surge	Other				
Ripples in Bend Drill Holes					Off	set									
Torque Waves in Extrusion Drawing					Out	t of C	Calibration								
Turning Sequence Finish					Out of Sequence										
• Wave/Twist in Tube Folio					Folio	Out	Outside Dimensions								

Date:

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IIN-D412-709

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5.0 PARTS LIST

Qty- -011-	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Part Number	Description
Х							D412-709-011	ESCAPE PANEL MODIFICATION KIT
	x						-D412-709-013	ESCAPE PANEL PUSH OUT WINDOW KIT
		Х					D412-709-015	HINGE PANEL DOOR MODIFICATION KIT
		1	Х				D412-709-017	HINGE PANEL DOOR REPLACEMENT WINDOW KIT
				Х			D412-709-019	CARGO DOOR PUSH OUT WINDOW KIT
					Х		D412-709-021	HINGE PANEL DOOR PUSH OUT WINDOW MODIFICATION KIT
					1	Х	D412-709-023	HINGE PANEL DOOR REPLACEMENT PUSH OUT WINDOW KIT
			1				D2126-0720	LOCKING SEAL
(1	-						D3118-3	SIGN ASSEMBLY
			and the second of				D3136-041	WINDOW ASSEMBLY
	1.			<u> </u>			D3136-043	WINDOW ASSEMBLY
1		-					D3224-1	FRAME
		·— ~	1				-D3236=1	WINDOW
	-					1	D3237-1-0720	SEAL RETAINER
	1			1			D3237-1-0980	SEAL RETAINER
						1	D3237-3-0720	SEAL FILLER
	1			1			D3237-3-0980	SEAL FILLER
72"							D3239-1 /	COVER
		1					D3240-1	FRAME
						1	D3543-1	HINGE PANEL DOOR PUSH OUT WINDOW
					1		D3543-3	HINGE PANEL DOOR PUSH OUT WINDOW FRAME
	1			1		1	D3561-1	WINDOW SEAL TOOL
(3		70-			-		AN6-20A	BOLT
/ 2		 				1	AN960JD10L	WASHER
, 5							AN960JD616-	-WASHER
7 5		T		<u> </u>			AN960JD616L	WASHER
2							MS21042L3	-NUT
/ 3	~						MS21042L6	NUT
7 2		<u> </u>					MS35207-262	SCREW>
	4		 					

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Revision: ${\bf C}$

Date: 06.11.27

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